

Date: Monday, 30/03/2009 12:54:22 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RIB/ GUSSET ASSY
Job Number	: 46723		
Estimate Number	: 13651		
P.O. Number	:	Part Number	: D3826041
This Issue	: 30/03/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3826 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 46367	Drawing Revision	: A
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 03/04/2009
Checked & Approved By	: <u>MF 09-03-28</u>	Qty:	6 Um: Each
Comment	: Est Rev:A 08-12-01 new issue DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22351	Basket Rib
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Basket Rib

batch: B 42627 → 5x B 46474 → 1x

MF 09/03/30

2.0	D2325	Support Gusset (350 Basket)
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Support Gusset (350 Basket)

batch: B 43289 → 12x

MF 09/03/30

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- use DT9434 to assemble D2325 support gusset together

2- locate D2325 on rib and weld as per dwg D3826

A/R ER316 S.S. Rod Batch: 11108775

MF 09/03/31 (64)

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

FD 09-03-31 (6)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

FD 09-03-31 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 30/03/2009 12:54:22 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB/ GUSSET ASSY

Job Number: 46723

Part Number: D3826041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket

PD 09-03-31 ⑥

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/01 *[Signature]*

Job Completion



MF
09-03-31

Dart Aerospace Ltd

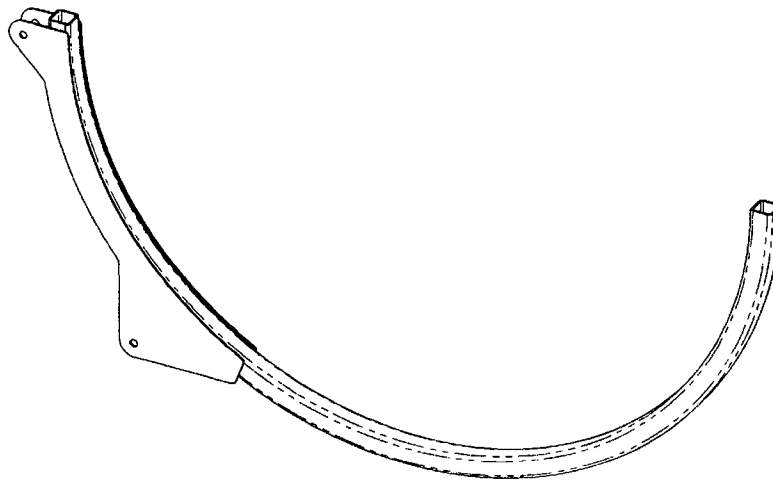
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3826-041 RIB/GUSSET ASSY

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSEMBLY
2	1	D2235-1	RIB
3	2	D2325	SUPPORT GUSSET

RELEASED
08/11/14

#416723

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3826	REV. A SHEET 1 OF 2
TITLE RIB/GUSSET ASSY	SCALE NTS
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NOTES:
MATERIAL: N/A
FINISH: NONE
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: 2.59 lbs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

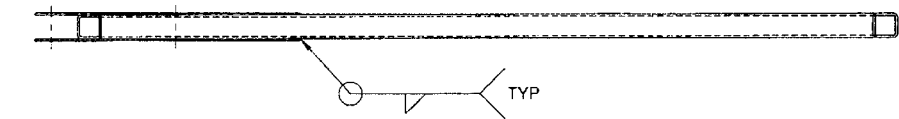
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

0.250



D2325
SUPPORT GUSSET
2 PL

D2235-1
RIB

D3826-041 RIB/GUSSET ASSY

46723

RELEASED
08/11/23

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
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